

Work Order ID 130130

130130

Page 1

Tuesday, February 24, 2015 10:37:57 AM

Item ID: D4049-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 2/24/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/24/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 15-2-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4049	B								

100 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw CUT BLANK 2.200" LONG 4 0 *[Signature]*
 15/02/24

110 0.00
110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 mill as per dwg and FOLIO FA900
 FOLIO REV: AA
 DWG REV: B 4 4 DAS
 14
 9-89
 15/02/24

DEBURR

Work Order ID 130130

Tuesday, February 24, 2015 10:37:57 AM

130130

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Item ID: D4049-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 2/24/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

4 0 DAS14
9-89

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

4 2152-25

140

Identify as per dwg & Stock Location: W/POO

0.00

140

Packaging

Memo

0.00

Packaging

4 12-15-25

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Item ID: D4049-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug
Start Date: 2/24/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/24/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

15/2/25
MF
15-2-25

Picklist Print

Tuesday, February 24, 2015 10:38:03 AM

Page 1

Work Order ID: 130130

130130

Parent Item: D4049-1

D4049-1

Parent Item Name: Lug

Start Date: 2/24/15

Required Date: 2/24/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP Rev:B
as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X1.500		Purchased		No		100	f	25.2490	0.1501	1			

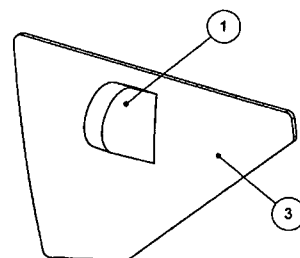
M304B0 500X1 500

304 BAR .500 x 1.50

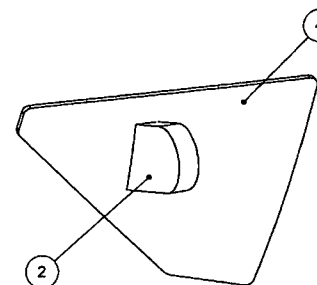
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT009	25.249	
113762	13.333	
116135	11.916	

1 on 2/15/02/24

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



D4049-041 MOUNTING LUG ASSY, LH

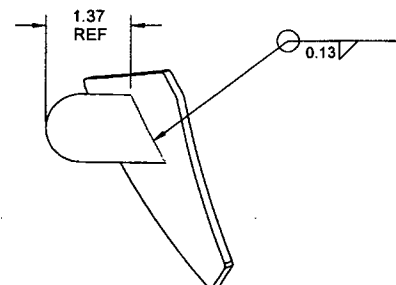
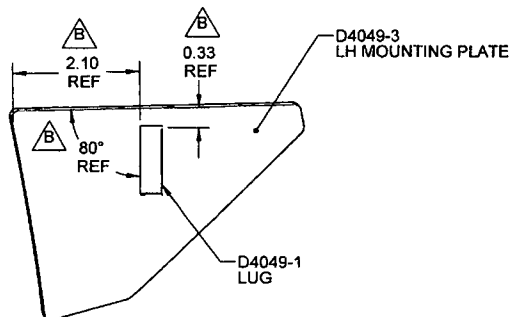
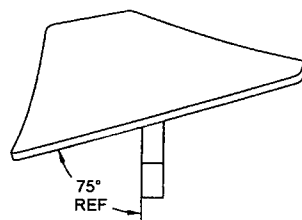


D4049-042 MOUNTING LUG ASSY, RH

RELEASED
2010-04-14
MP

Handwritten: 15-2-24
13030

B	80" WAS 83", 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4049	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MOUNTING LUG ASSY	NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



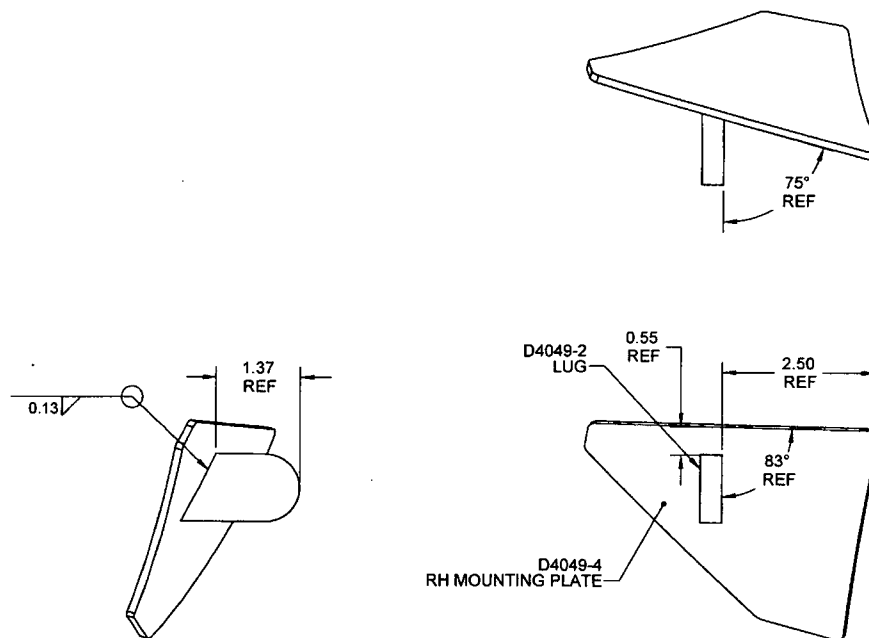
D4049-041 MOUNTING LUG ASSY, LH

RELEASED
2010-04-14
JMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

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MFG. APPR.	<i>[Signature]</i>	TITLE MOUNTING LUG ASSY	SHEET 2 OF 7
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DATE	10.03.19		



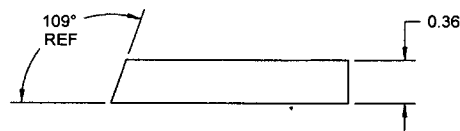
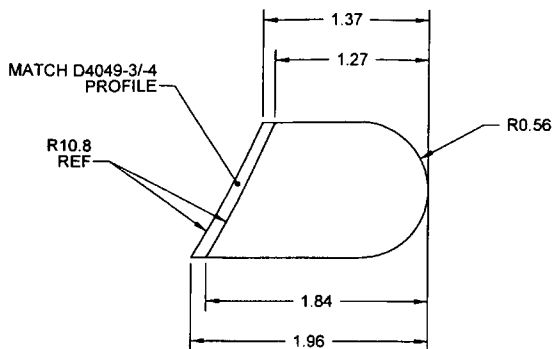
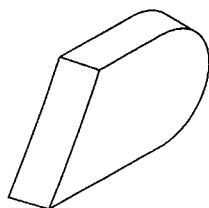
8 D4049-042 MOUNTING LUG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

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MFG. APPR.		D4049	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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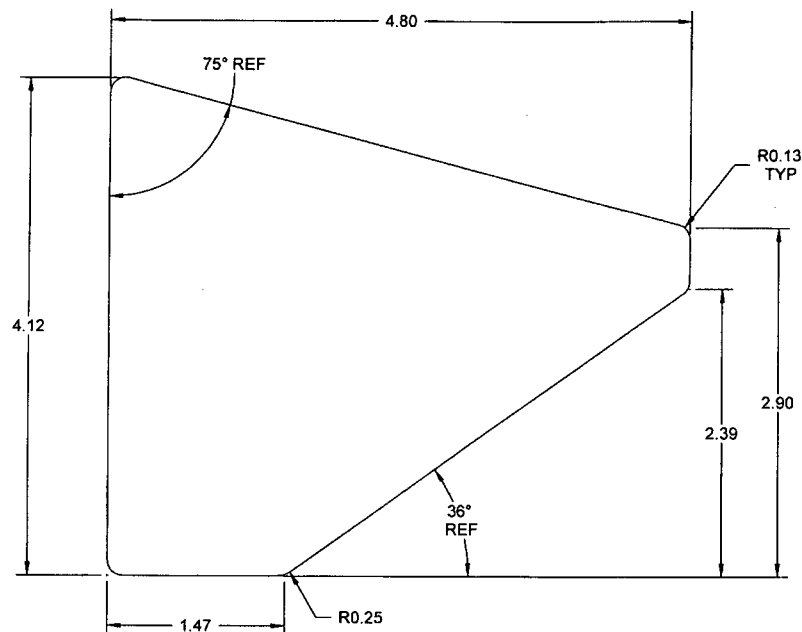
D4049-1 LUG (SHOWN)
D4049-2 LUG (OPPOSITE)

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2010-04-14
NR

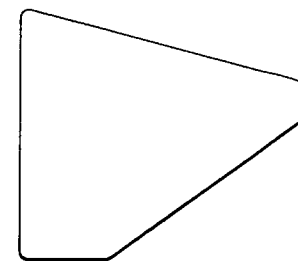
NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

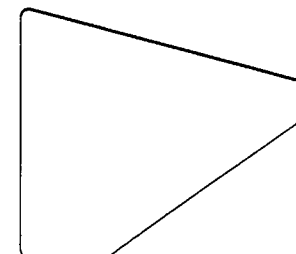
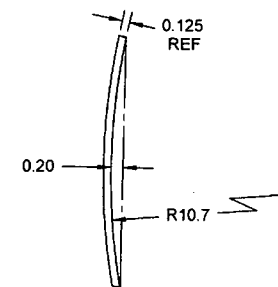
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4049	SHEET 4 OF 7
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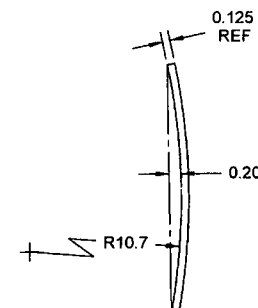
D4049-3F FLAT PATTERN



**D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)**



**D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)**

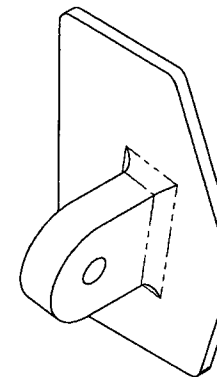


NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs

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2010-04-14

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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4049	SHEET 5 OF 7
APPROVED	RF	TITLE	SCALE
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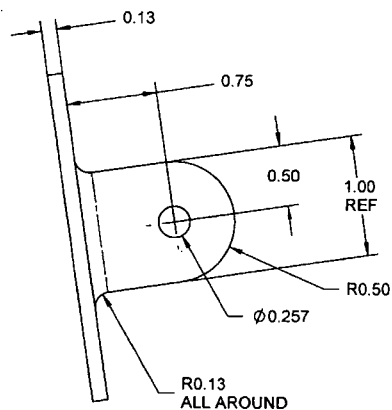


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2010-04-16

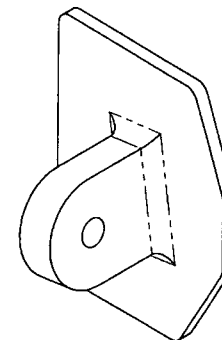
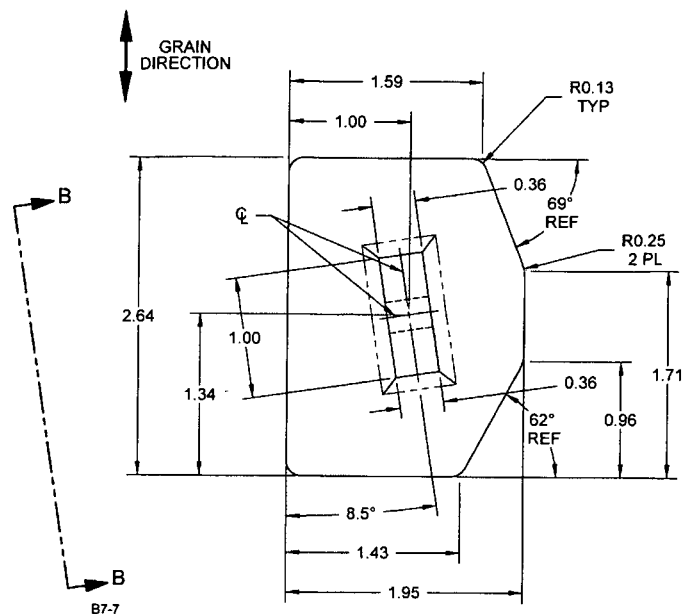
NOTES:

- NOTES:
- 1) MATERIAL: 6061-T6/T61/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4049	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG ASSY	NTS
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VIEW B-B B5-7



D4049-8 MOUNTING LUG, RH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4049	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG ASSY	NTS
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2010-04-14
[Signature]

